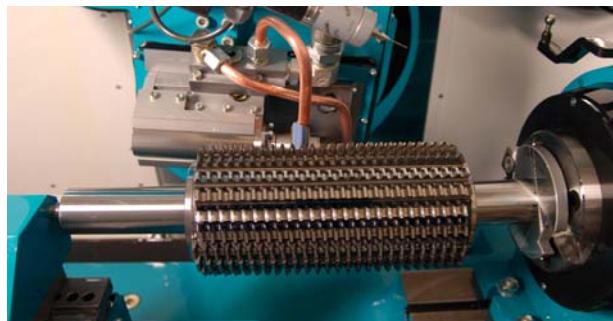


Gear Hob Ø110 L210mm

A12-030

The preturned gear hob is usually profiled with a conventional wheel, which is formdressed on the integrated CNC dressing unit. With the highly dynamic linear axis of the machine, the profile execution is done at high frequency. The cycle time includes dressing starting from a cylindrical wheel. In case the wheel is already formed the cycle time reduces drastically.



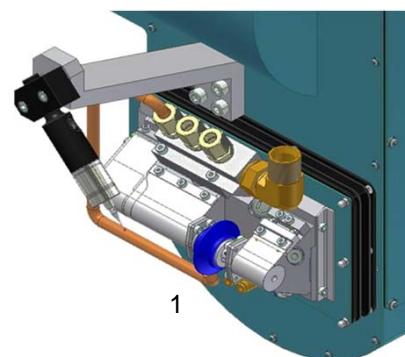
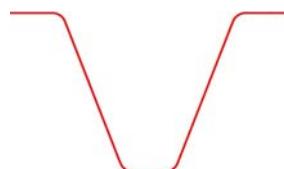
1. Cycletime for Production

Tool specifications		
	Diameter 110 mm, Length 210mm, Material HSS, 3 Gashes, 21 Teeth	
Operations	Probe	Dress
Feed [mm/Min]	2000	150
Power [kW]		1
Cutting feed [m/s]		32
Used wheels	full	1
Grinding time [s]	20	1800
Total cycle time	59 Min 20	

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø65 DXF Conventional



3. Machine and Software Requirements



Machines: 6 axes CNC grinders : **GEMINI hhp**
 Control: Fanuc 31i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 5
 Engineer: DI, 04.05.2009